

white

Date: Friday, 11/23/2007 11:05:48 AM  
 User: Chantal Lavoie

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: CAP	
Job Number	: 35972		Part Number	: D2855	
Estimate Number	: 10519		Drawing Number	: D2855 REV. A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/23/2007	S.O. No. : N/A	Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 12/14/2007	
Previous Run	: 35920		Qty:	18	Um: Each
Written By					
Checked & Approved By					
Comment	Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: 5113 Cast per Dwg D2855 Material Release Note Required	(18) 07/11/23
2.0	D2855P	Cap	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s) CAP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	7/12/12 SP 18X
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	5 07/12/13 X 18
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr	FF 07-12-18 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/23/2007 11:05:48 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 35972

Part Number: D2855

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



✓ 07/12/19 (18)

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



M105914



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

✓ 07/12/19 (18)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M-18X



07/12/19

Comment: INSPECT POWDER COAT

9.0 ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 36.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 ALS7-1032-225 Insert

M100489 \*?

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

✓

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

✓

07-12-19

X 18

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

✓ 07/12/19 X 18

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F10-20

✓ 07-12-19 X 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/12/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/23/2007 11:05:48 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 35972

Part Number: D2855

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(18)

Comment: FINAL INSPECTION/W/O RELEASE

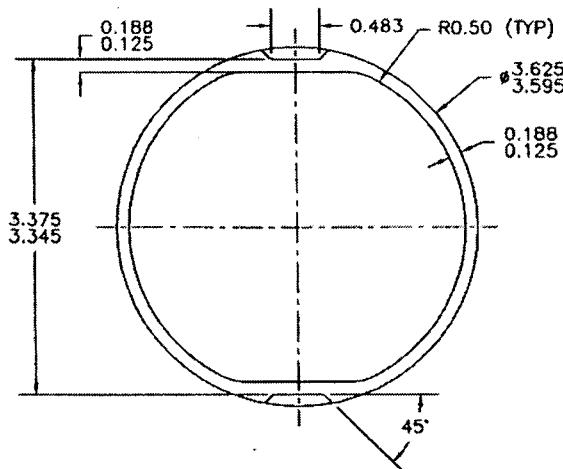
Des/10/08

Job Completion

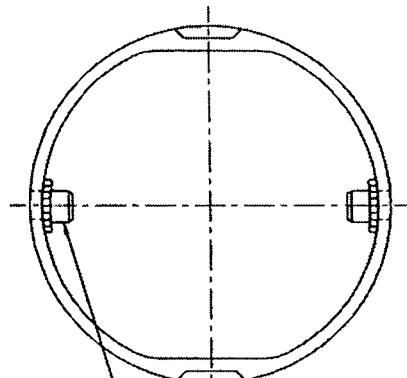


2007/12/19 CL

D2855 CASTING DETAIL



D2855 FINISHING DETAIL

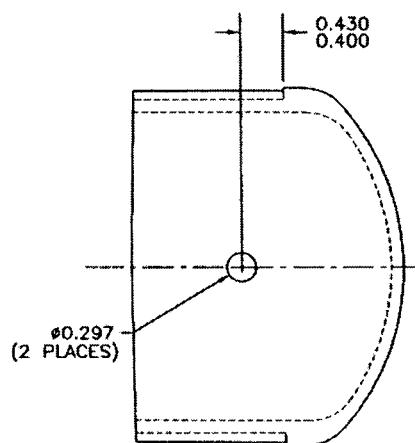
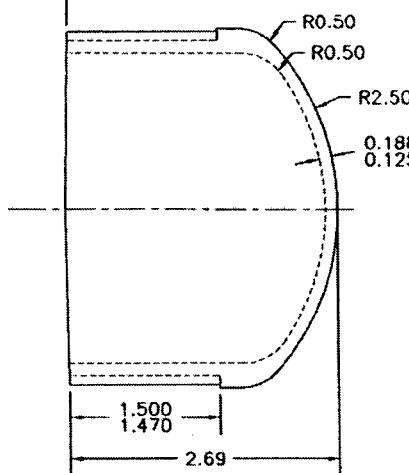


INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

1" TAPER



**RELEASED**  
16.12.14 DS



DESIGN <i>44</i>	DRAWN BY <i>MM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2855
DATE 98.12.12		TITLE CAP
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)

REV. A  
SHEET 1 OF 1  
SCALE  
NTS

*KE 99.09.12*

*43*

**Aluminum Foundry Ltd**

714-716 Calais  
Dorval, Québec H9P 2P3  
Tel: (514) 631-1331  
Fax: (514) 631-8448  
email: info@foundryafpw.com

**Packing Slip**

Packing Slip No.: 32338  
Shipped Date: Dec 10, 2007

Sold to:	Ship to:
<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Tel. (613) 632-3336 Fax (613) 632-4443	
Order No.: 5113	
Shipped By: PUROLATOR	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z0E8046	Each	D2855 CAP REV.A	30

Received by:

Date:

Comment:

CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCE

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

714-716 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à Shipped	<b>DART AEROSPACE</b>	A.F. & P.W.Série no./Serial no.
		Packing
	<b>1270 Aberdeen Street</b>	Date: <u>013/12/2007</u> Slip No. <u>32337</u>
	<b>Hawksbury, ON, K6A 1K7</b>	Vôtre No. Commande <b>5037, 5113</b> Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificates di détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
70	<b>D 2855 CAP</b>	<b>Z098046</b>	<b>A356.2</b>	<b>Ingot#850156</b>
30	<b>D 2965 CAP</b>	<b>Z200080</b>	<b>A356.2</b>	<b>Ingot#850156</b>

**Analyse  
Analysis (as In Ingot)**

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.40%		
(Zn)	<0.01%		
(Ti)	0.18%		

Donne Yield :	<b>Résistance a la tension : Tensile Strength :</b>	<b>Allongement par pouce carré : P.S.I. Elongation :</b>
------------------	---	--

Pour et au nom de  
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :  
Par/Per :

Coc-100